

MOLIBAZ

TOP FEATURES

- Excellent operability in all position welding except downhill.
- Stable arc with excellent bead shape and low spatter.
- Efficiency about 120%.

CLASSIFICATION

AWS A5.5 E7018-A1 H4
EN ISO 3580-A E Mo B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Mo
≤0.06	0.8	0.4	≤0.020	≤0.015	0.55

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-20°C
AWS A5.5	AW	≥390	≥490	≥22		not specified
AWS A5.5	PWHT 620°C x 1h	≥390	≥490	≥22		not specified
EN ISO 3580-A	AW	≥355	≥510	≥22		≥47
EN ISO 3580-A	PWHT 620°C x 1h	≥355	≥510	≥22		≥47
Typical values	AW	≥460	530-610	≥24		≥47
Typical values	PWHT 620°C x 1h	≥430	510-610	≥24		≥47

*AW: As-welded; PWHT: Postweld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 450	110-135
4.0 x 450	140-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	87	2.0	W000384493
3.2 x 450	VPMD	54	2.5	W000384494
4.0 x 450	VPMD	37	2.5	W000384496

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.